

# Work Order ID 57939

April 21, 2010 7:44:22 AM



Page 1

Item ID: D4037-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Crossbeam

Start Date: 23/04/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 30/04/2010 Req'd Qty: 2.00



Customer:

Reference: *10.04.21.*

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4037

B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut blank as per file D4037-1\_BLANK

*MAT NOT PULLED*

*B10-4-26*

*(1)*

110

0.00



HAAS I

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLI FA877 AND DWG

FOLIO REV: *AA*

DWG REV: *B*

DEBURR

*amf/ SP 10/04/07*

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Page 2

Item ID: D4037-1

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

130

QC B

0.00



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

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Page 3

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

⇒ M

10/04/29

(X1)

9

Memo

START: 8:15am

TEMP: 320°F

FIN: 8:45am

0.00

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

⇒ M 10/04/29 (10)

Memo

170



Packaging

Packaging

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

10-4 29 80

Memo

0.00

# Work Order ID 57939

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Page 4

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Cust Item ID:

Required Date: 30/04/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/04 *[Signature]*  
ME  
10-4-29

# Picklist Print

April 21, 2010 7:44:22 AM

Page 1

Work Order ID: 57939

Parent Item: D4037-1

Parent Item Name: Aft Crossbeam

Comments: IPP REV:A NEW ISSUE 09-12-14 JLM VERIFIED BY:EC IPP  
REV:B AS PER REV B 10-04-19 JLM VERIFIED BY:EC

Start Date: 23/04/2010

Required Date: 30/04/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.000X15.00 0		Purchased	No			100	f	6.5000	8.2105			



6061-T6 Bar 1.00 x 15.00



B10-4-26

D4037-005  
Jul 10.05.04

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT07

9544

6.5

6.5

B33680

M 165258

M165258

DART AEROSPACE LTD		Work Order: 57939
Description: <i>Cross Beam</i>		Part Number: D4037-1
Inspection Dwg: D4037 Rev: 13		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
530	$\pm .010$	.526	✓			
.25	$\pm .030$	.270	✓			
2.00	"	2.01	✓			
2.75	"	2.760	✓			
1.00	"	1.00	✓			
R.032	"	.032	✓			
42.87	"	42.87	✓			
1.38	"	1.375	✓			
1.750	$\pm .010$	1.743	✓			
2.125	"	2.124	✓			
2.250	"	2.251	✓			
.875	"	.868	✓			
.875	"	.863	✓			
6.000	"	5.995	✓			
1.125	"	1.126	✓			
.86	$\pm .030$	.862	✓			
1.38	"	1.38	✓			
1.38	"	1.38	✓			
8.04	"	8.047	✓			
5.29	"	5.293	✓			
6.00	"	6.002	✓			

Measured by: <i>SP</i>	Audited by: <i>Y</i>	Prototype Approval:	N/A
Date: 10/04/27	Date: 10/04/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJJ/JLM	

8

7

6

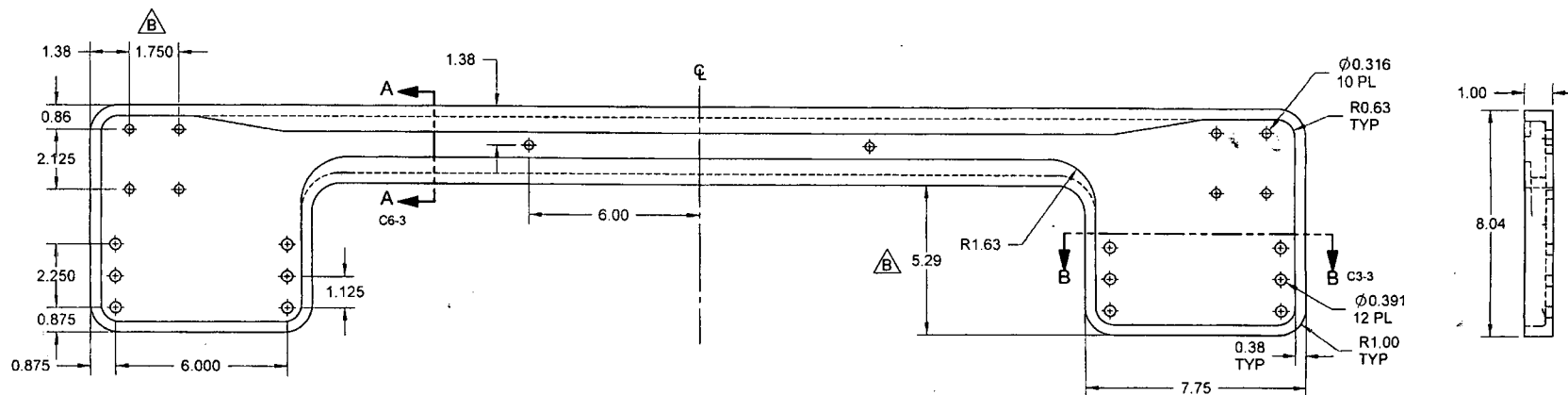
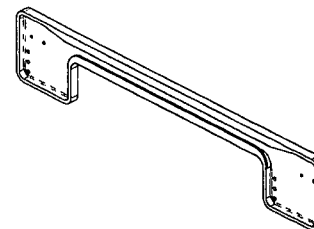
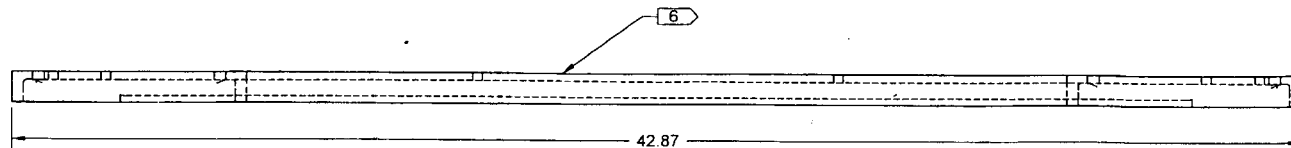
5

4

3

2

1



**D4037-1 AFT CROSSBEAM**

**RELEASED**  
2010-04-14  
JW

**NOTES:**

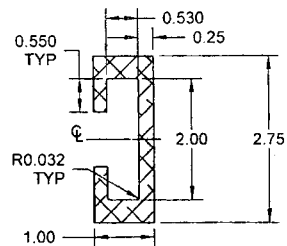
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 1.000 THICK  
PER AMS-QQ-A-250/11 (OR AMS 4025/4027)  
REF DART SPEC M6061T6S1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4037-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 8.48 lbs
- 8) MACHINE PER DART SOLIDWORKS PART "D4037-1\_REVB.SLDPRT"

*w/o 57939*

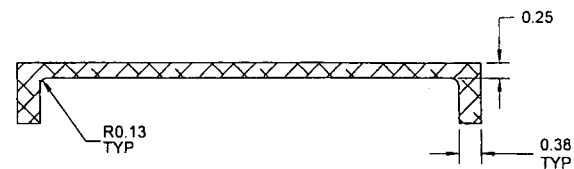
B	ADJUST DIMS AND REPOSITION HOLES, ZN B4-1, C8-1, C8-2	10.02.10
A	NEW ISSUE	HS 09.12.16
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	10.02.10	

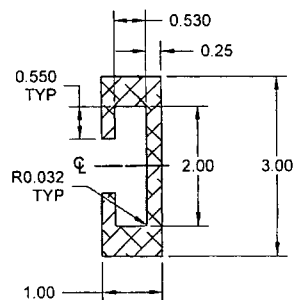
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D4037</b>	REV. B SHEET 1 OF 3
TITLE <b>CROSSBEAM</b>	SCALE NTS
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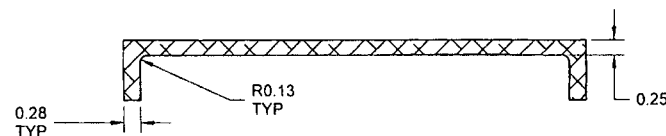
**SECTION A-A** B6-1  
SCALE 2X



**SECTION B-B** B2-1  
SCALE 2X



**SECTION C-C** B6-2  
SCALE 2X



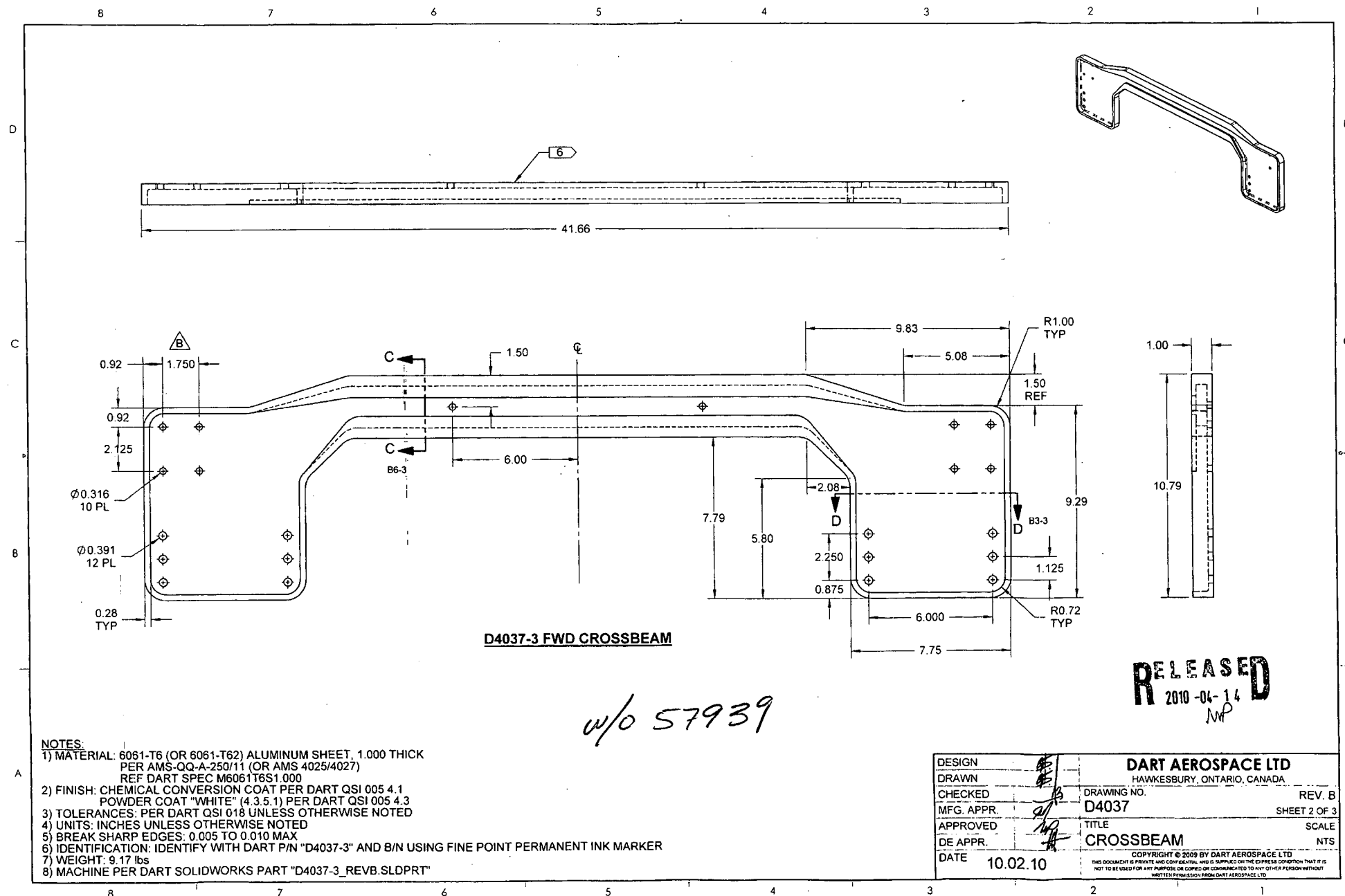
**SECTION D-D** B3-2  
SCALE 2X

**RELEASED**  
2010-04-16

*w/o 57939*

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4037</b>	REV. B
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE <b>CROSSBEAM</b>	SCALE
DE APPR.			NTS
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2010-04-14  
MP